

Date: Monday, 2/27/2006 4:17:35 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SEAT PAN
Job Number	: 25962		
Estimate Number	: 11092		
P.O. Number	: N/A	Part Number	: D30221
This Issue	: 2/27/2006 S.O. No. : N/A	Drawing Number	: D3022 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 25796	Material	: N/A
Written By	: <u>See Comment Below</u>	Due Date	: 3/30/2006
Checked & Approved By	: <u>0602.28w</u>	Qty:	1 Um: Each
Comment	: Est. C 02.01.23 Revised NG		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S032	2024-T3 .032 sheet
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Comment: Qty.: 1.7044 sf(s)/Unit Total : 1.7044 sf(s)

2024-T3 .032 sheet

Material: 2024-T3 sheet (QQ-A-250/4) 0.032"

Batch: MID1422
06/07/26 ①

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Cut seat pan (32.00" x 14.75") as per template D3022-1T1 & Dwg D3022.

2-Deburr

06/07/26 ①

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

06-07-26 ①

4.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Form as per Dwg D3022

06-07-26 ① P10

5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Transfer drill Seat Pan From Frame

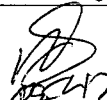
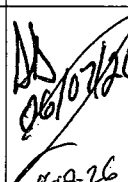

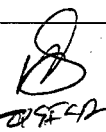

2-Deburr

06/07/26 ①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/08/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-07-26	4.0	Wtfl cracked during bending. Part scrapped		Destroy & replace. Install larger rod. die. on top.	 06/07/26 06-07-26			 06-07-26

NOTE: Date & initial all entries

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Drawing Name: SEAT PAN

Job Number: 25962

Part Number: D30221

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD 06-07-28

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 06 07 31 (1)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

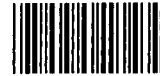
Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

SC 06/07/31 (1)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SR 06/08/08 (1)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SR 06/08/08 (1)

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DR 06/08/15 (1)

Job Completion



CE 06/08/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

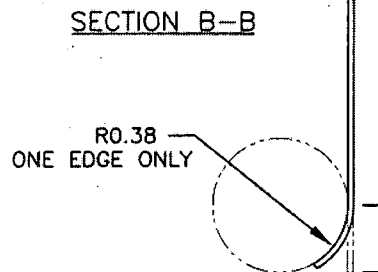
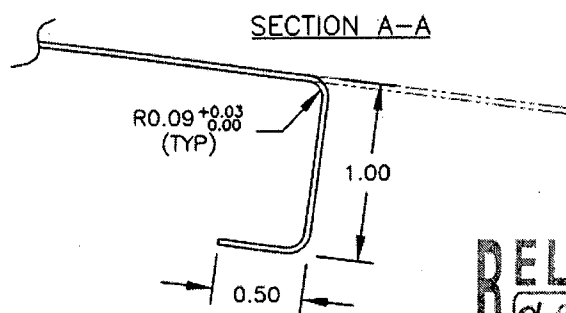
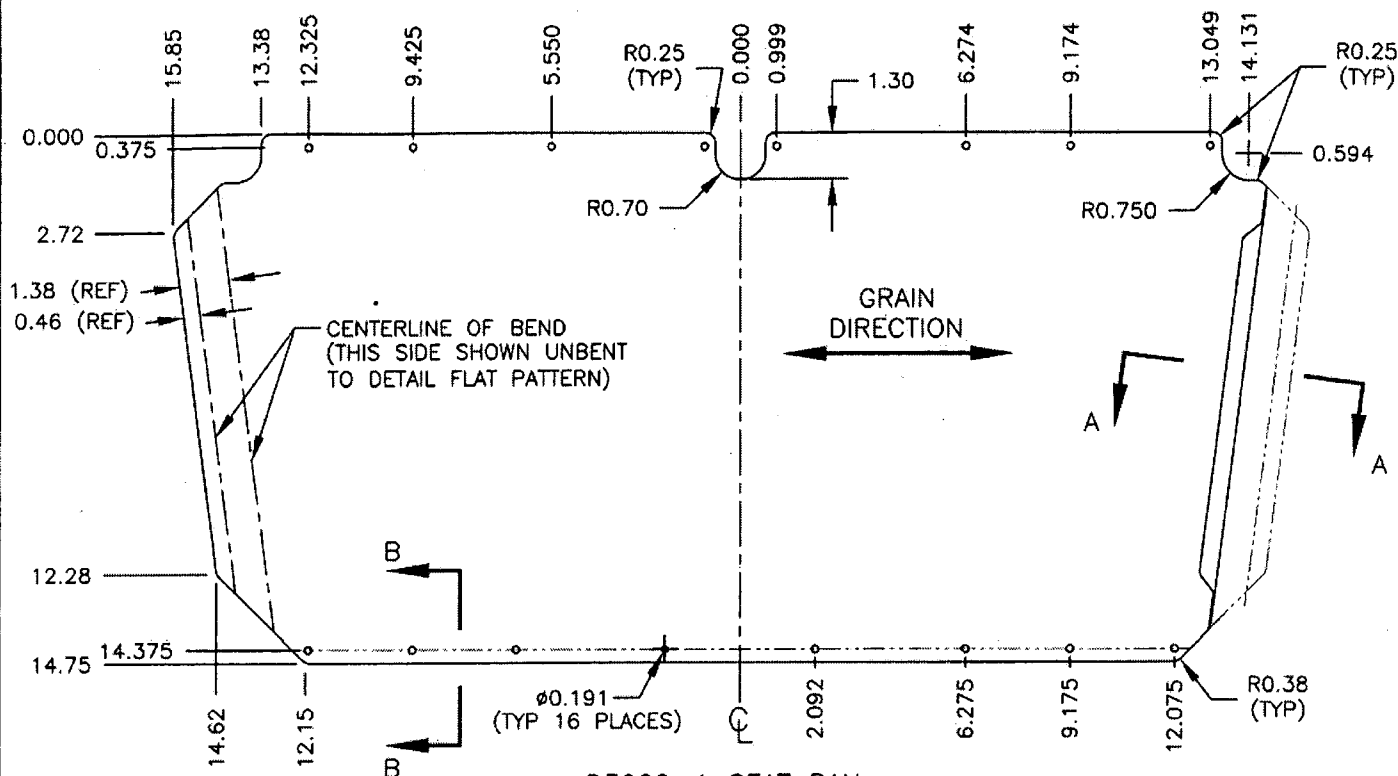
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3022	REV. A SHEET 1 OF 1
DATE 01.05.18		TITLE SEAT PAN	SCALE 1:5
A	01.05.18	NEW ISSUE	



RELEASED
01.05.18

NOTES:

- 1) SHAPE IS SYMMETRIC ABOUT CENTERLINE, HOLE PATTERN IS NOT
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

SHOT COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 25962

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